

Split-1

Work Order ID 105568 -1

\*105568\*

Page 1

August-08-13 8:58:58 AM

Item ID: D3017-7

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Lug

Start Date: 8/08/13 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 8/08/13 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-08-08

Tooling:

Date:

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3017	Rev B

100	FLOW WATER JET	0.00	24	0	Ac
*100*	Memo	0.00	13.08.13		
Waterjet	1-Cut as per Dwg D3017				
FLOW CNC Waterjet	Dwg Rev: B				
	Prog Rev: B				

100	2-Deburr	0.00	24	0	Ac
*100*	Memo	0.00	13.08.13		
Waterjet	1-Cut as per Dwg D3017				
FLOW CNC Waterjet	Dwg Rev: B				
	Prog Rev: B				

110	QC2- Inspect parts off machine FAI/FAIB	0.00	24	0	Ac
*110*	Memo	0.00	13.08.13		
QC	1-Cut as per Dwg D3017				
Quality Control	Dwg Rev: B				
	Prog Rev: B				



**Work Order ID 105568**

August-08-13 8:58:58 AM

**\*105568\***

Page 2

Item ID: D3017-7

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Lug

Start Date: 8/08/13

Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 8/08/13

Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

**\*120\***

QC

Quality Control

QC8- Inspect parts - second check

0.00

5  
3 7 8

0.00

15.8.13

24  
Calm

130

**\*130\***

Brake NC

NC BRAKE

0.00

0.00

Brake NC

Memo

1-Deburr

2-Form as per Dwg D3017 using DT9835

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

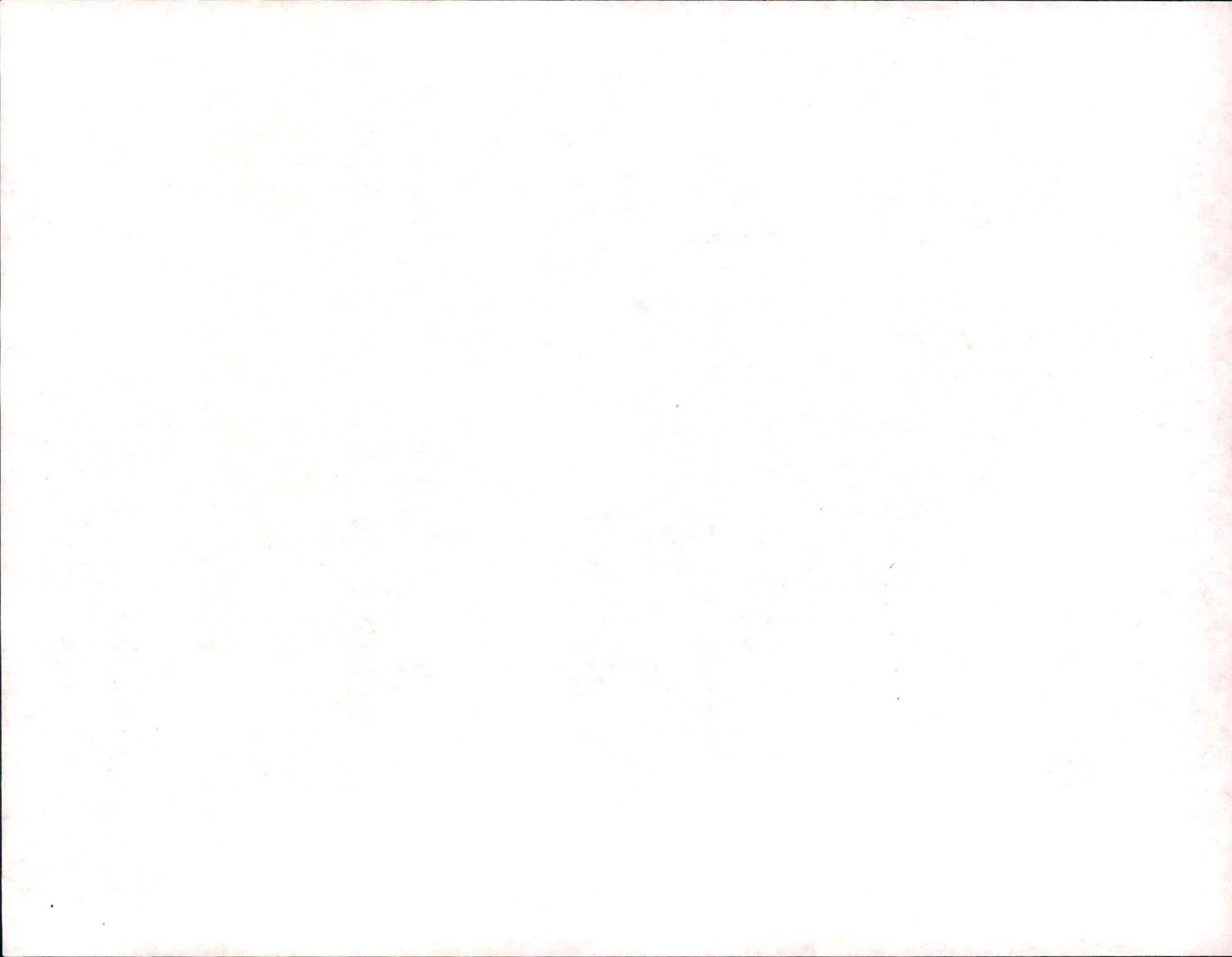
0.00

DAS  
16  
13/08/13

0.00

71

GJ/14



Work Order ID 105568

August-08-13 8:58:58 AM

\*105568\*

Page 3

Item ID: D3017-7

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Lug

Start Date: 8/08/13

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 8/08/13

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

\*150\*

Packaging

Packaging

0.00

1

8/13-8/14

Packaging

Memo

0.00

Identify and bag with light oil (Vactra oil #2), then Stock  
Location: WTF over

160

\*160\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLS 1308-15

PL 13.8.14

Split 1



# Picklist Print

Page 1

August-08-13 8:58:57 AM

Work Order ID: 105568

Start Date: 8/08/13

Required Date: 8/08/13

Parent Item: D3017-7

Start Qty: 12.00

Required Qty: 12.00

Parent Item Name: Lug

Comments: IPP: B03.05.09ReformatKJ/RF  
IPP Rev:C 08-04-11 now made on water jet DD verified by:EC  
revB DD verified by:JLM

IPP RevB: as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	124.1903	0.102	1.2884208		13-08-13	A

Location	Loc Qty	Loc Code
MAT020	124.190263	
11612	4.2	
123049	17.340263	
124283	102.65	

Shp  
13-08-13



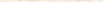
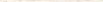
124283 → 2.6



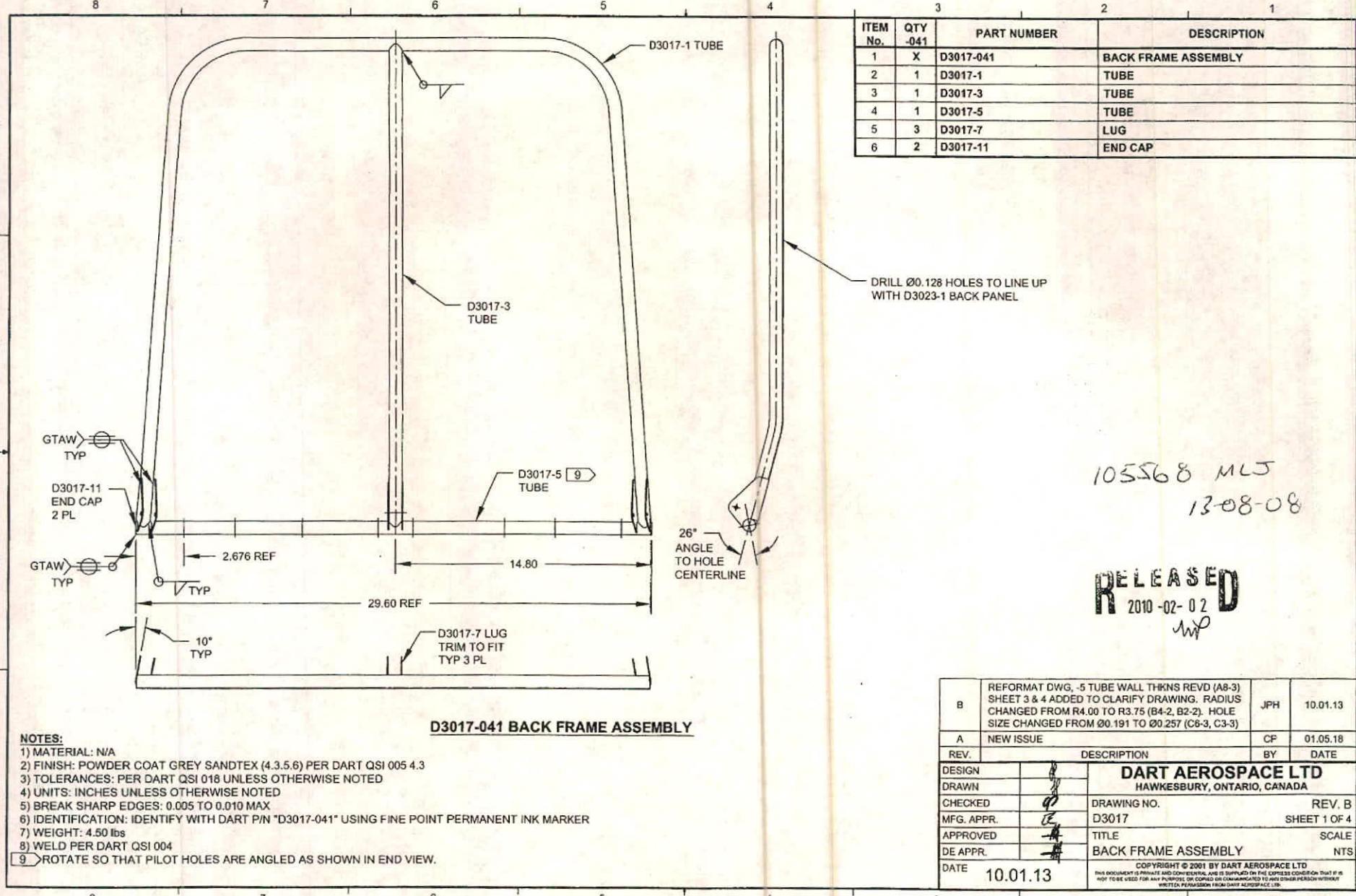
DART AEROSPACE LTD	Work Order:	105568
Description: Lug	Part Number:	D3017-7
Inspection Dwg: D3017	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>Ac</i>	Audited by:	<i>DS 27</i>	Preliminary Approval:	
Date:	13.08.13	Date:	13.8.13		Date:

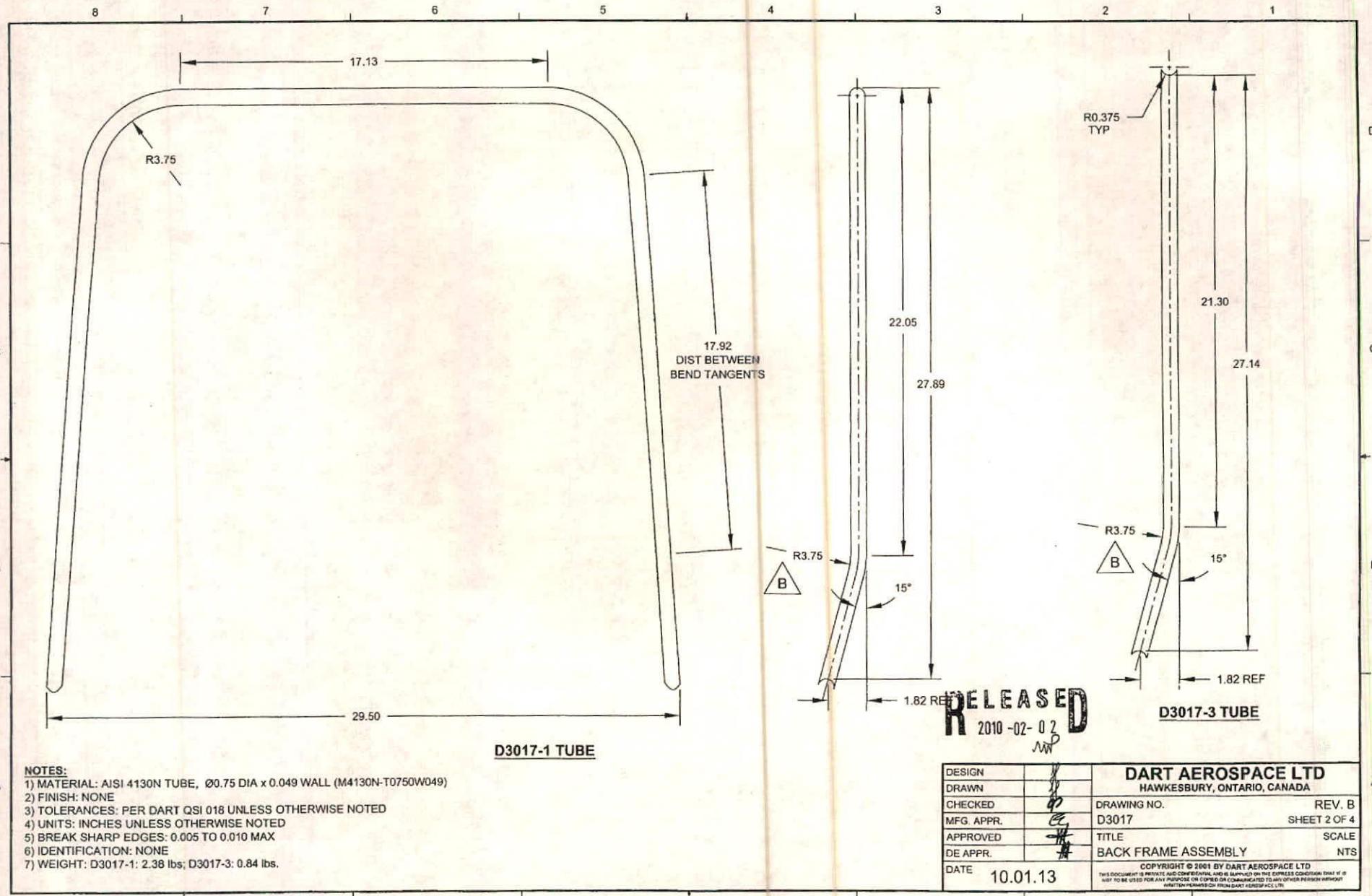
Rev	Date	Change	Revised by	Approved
A	05.03.04	New Issue	KJ/JLM	
B	11.06.21	Dwg Rev updated	KJ	







105568





105568

8 7 6 5 4 3 2 1

D

C

B

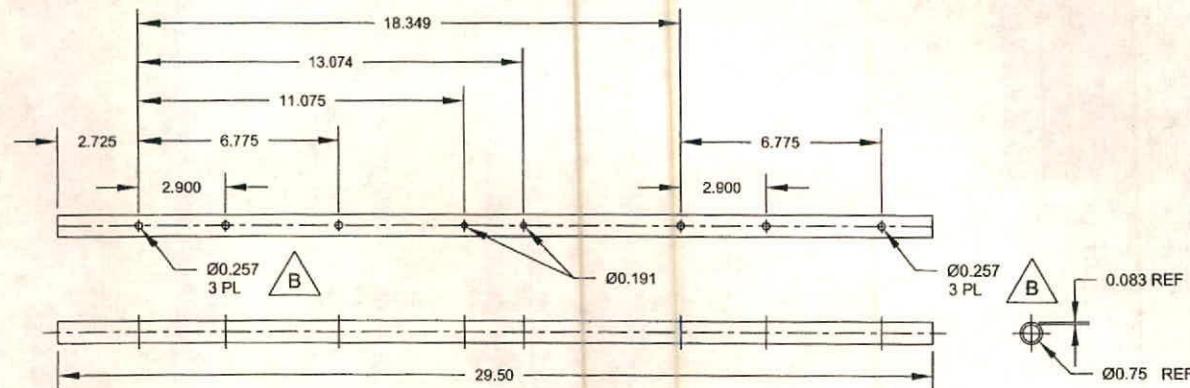
A

D

C

B

A



D3017-5 TUBE

**NOTES:**  
 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.89 lbs



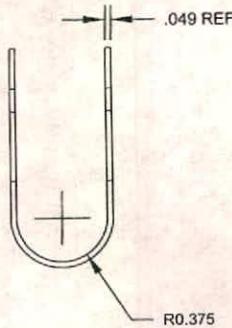
8 7 6 5 4 3 2 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO.	SHEET 3 OF 4
APPROVED		D3017	
DE APPR.		TITLE	SCALE
		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD	
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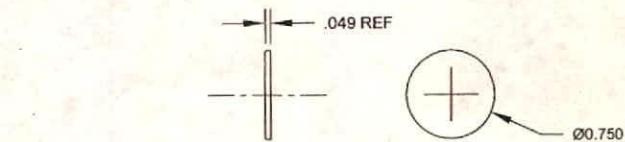
 RELEASED  
 R 2010-02-02  
 MP



105568



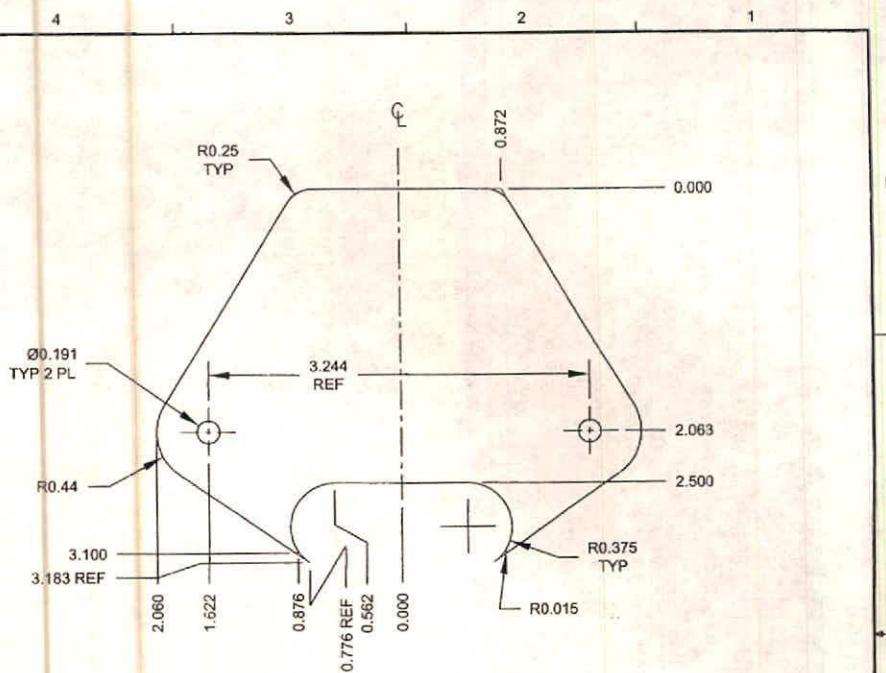
**D3017-7 LUG**  
BENDING DETAIL  
MAKE FROM D3017-7F



**D3017-11 END CAP**

**NOTES:**

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.



**D3017-7F FLAT PATTERN**  
PART IS SYMMETRIC  
ABOUT CENTERLINE

RELEASED  
2010-02-02  
AM

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. B
MFG. APPR.		DRAWING NO. D3017 SHEET 4 OF 4
APPROVED		TITLE BACK FRAME ASSEMBLY
DE APPR.		SCALE NTS
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